

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023474**Date Inspected:** 08-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

TA YARD

OBG Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AH-002 [Side Panel (SP) 3144B to Edge Panel (EP) 3029A, Complete Joint Penetration (CJP) weld at panel point (PP) 125 to PP 127]. The welder is identified as 037932 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020P-104 [WT stiffener on Top anchorage plate (AP) 3018A to Floor Beam (FB) 3320A, CJP weld at PP126]. The welder is identified as 066479 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The SMAW process on weld joint no: SEG3020P-126 [I-rib stiffener on Top anchorage plate (AP) 3018A to Floor Beam (FB) 3320A, CJP weld at PP126]. The welder is identified as 037779 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020S-111 and 115 [Diaphragm plate X4989C to diaphragm plate X8533E, CJP weld at PP125.5]. The welder is identified as 045246 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-B-U2-FCM-1.

Repair welding of weld joint no: SEG3020R-174 [Edge Beam (EB) 3054A to FB 3321A, CJP weld at PP 126]. The welder is identified as 066421 and was observed welding in the 1G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2231-Repair-ESAB. Repair welding was done as per Welding Repair Report (WRR): B-WR 20917 Rev-0. See attached photograph for further details.

Repair welding of weld joint no: SEG3020T-165 [EB 3059A to FB 3319A, CJP weld at PP 125.5]. The welder is identified as 066459 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20917 Rev-0. See attached photograph for further details.

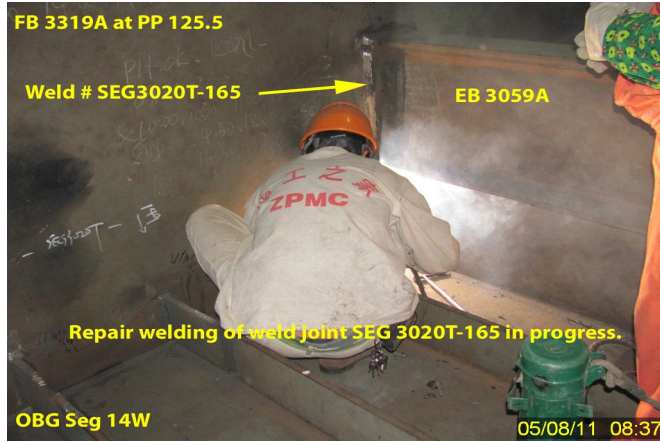
Repair welding of weld joint no: SEG3020T-129 [I-rib on Bottom Plate (BP) 3094A to FB 3319A, CJP weld at PP 125.5]. The welder is identified as 045213 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20915 Rev-0.

Repair welding of weld joint no: SEG3020AL-157 [I-rib on SP 3140B to FB 3319A, CJP weld at PP 125.5]. The welder is identified as 067572 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20918 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer